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TITLE : METHOD AND APPARATUS FOR  
FILLING PLASTIC RAW MATERIAL

第 1 の工程

原料の供給



第 2 の工程

原料の液位検知



第 3 の工程

注入流量の切り替え制御



第 4 の工程

原料の満杯検知



第 5 の工程

原料の供給停止

ABSTRACT : PROBLEM TO BE SOLVED: To provide a method and apparatus for filling a plastic raw material for solving the lowering of productivity caused by the reduction of a supply flow rate generated by the volume difference of a cavity and a rise in the viscosity of the plastic raw material in a cast molding method for a plastic product.

SOLUTION: A method for detecting the liquid level of the plastic raw material to change over an injection flow rate and a raw material supply method not affected by a change in viscosity are conceived. As a result, the changeover of a flow rate becomes possible at a predetermined height in all of molds and a filling time can be shortened to a large extent and productivity is enhanced. Further, since the plastic raw material is not pressed by compressed air, the generation of air bubble failure caused by the dissolution of air can be prevented.

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